

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

690 Walnut Ave. St. 150

Vallejo, CA 94592-1133

(707) 649-5453

(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-019730**Date Inspected:** 10-Jan-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Qiu Wen.**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG components.**Summary of Items Observed:**

On this day CALTRANS OSM Quality Assurance Inspector (QA) Mr. Shailesh Wadkar was present during the times noted above for observations relative to the fabrication of the Self Anchored Suspension (SAS)

Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island, in Shanghai, China. QA Inspector observed and/or found the following:

Bay 14:

This QA Inspector observed the following work in progress:

OBG Seg 13AW:

The Shielded Metal Arc Welding (SMAW) process on weld joint no: SEG3013AA-086 [Floor Beam (FB) 3200A to K-Plate KP3015A, complete joint penetration (CJP) weld, at panel point (PP) 120]. The welder is identified as 069841 and was observed welding in the 4G position. ZPMC QC was identified as Liu Feng. The welding variables recorded by QC appeared to comply with welding procedure specification (WPS):

B-P-2214-TC-U4b-FCM-1.

Repair welding of weld joint no: SEG3013H-003 [FB to Bottom Panel (BP), CJP weld, at PP119.65]. The welder is identified as 045204 and was observed welding in the 2G position. Welding process was identified as SMAW. ZPMC QC was identified as Liu Feng. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per Welding Repair Report (WRR): B-WR 19199

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Rev-0.

OBG Seg 13BW:

This QA Inspector observed that fit-up of Deck Panels (DP3136 and DP3137) with Seg 13BW is in progress. See attached photo for further information.

OBG Seg 13AW and Seg 13BW:

This QA Inspector observed that the Corner Assemblies (W4 – cross Beam Side) for Seg 13BW and Seg 13CW are mounted on the respective segments. Fit-up is to be done. See attached photo for further information.

ZPMC personnel performing base metal repair welding on Longitudinal Diaphragm (LD) 3033A and LD 3036A at PP122.5. The welder is identified as 045196 and was observed welding in the 3G position. Welding process was identified as SMAW. ZPMC QC was identified as Wang Xiang Ping. Repair welding was done as per WRR: 19640 Rev-0. Base metal repair welding was done after the removal of T-stiffeners; X4314G (at W4) and X4349D (at W3). T-stiffeners were needed to be removed to perform alignment and drilling of splice plate at PP122 – PP122.5. See attached photo for further information.

OBG Seg 14W:

The Flux Cored Arc Welding (FCAW) process on weld joint nos: SEG3020BB-046 [BP to Sub-Assembly (SA) Plate, CJP weld]. The welder is identified as 066695 and was observed welding in the 2G position. ZPMC QC was identified as Zhu Lin. The welding variables recorded by QC appeared to comply with WPS: B-T-2232-ESAB.

The FCAW process on weld joint no: SEG3020V-073 (LD3049A to FB3315A, CJP weld at PP125). The welder is identified as 045175 and was observed welding in the 3G position. ZPMC QC was identified as Zhu Lin. The welding variables recorded by QC appeared to comply with WPS: B-T-2233-ESAB.

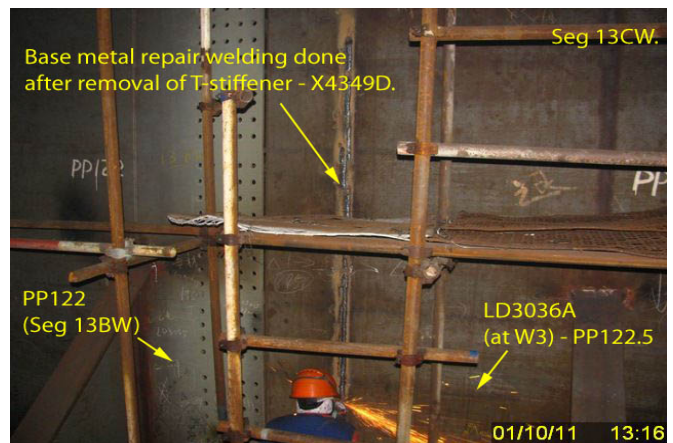
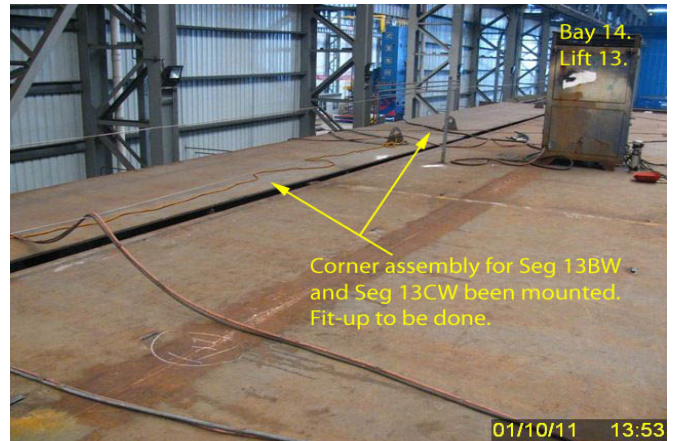
The SMAW process on weld joint no: SEG3020P-005 (FB3349B to FB3349C, CJP weld at PP126.5). The welder is identified as 067520 and was observed welding in the 2G position. ZPMC QC was identified as Zhu Lin. The welding variables recorded by QC appeared to comply with WPS: B-P-2212-B-U2-FCM.

Repair welding of weld joint no: SEG3020E-056 (FB3343A to BP3093A, CJP weld, at PP128.3). The welder is identified as 067864 and was observed welding in the 2G position. Welding process was identified as SMAW. ZPMC QC was identified as Zhu Ling. The welding variables recorded by this QC appeared to comply with WPS: 345-SMAW-2G(2F)-FCM-Repair. Repair welding was done as per Critical Welding Repair Report (CWR): CWR 2734 Rev-0.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

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Summary of Conversations:

No significant conversations were reported on this date.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang; phone: 15000422372., who represents the Office of Structural Materials for your project.

Inspected By: Wadkar,Sailesh
Reviewed By: Patterson,Rodney

Quality Assurance Inspector
QA Reviewer